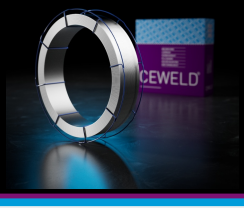

CEWELD SA 318

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid stainless steel welding wire for submerged arc welding stabilized stainless steels with high Mo content

APPLICATIONS

The alloy is widely used in the chemical and food-processing industries, as well as in shipbuilding. Suitable for welding stabilized corrosion-resistant Cr-Ni-Mo steels for working temperatures up to 400°C.

PROPRIÉTÉS

CEWELD® SA 318 is engineered to a very precise analysis to create a weld deposit of high purity, superior hot cracking and corrosion resistance. CVN toughness down to –120 °C, resistant to intergranular corrosion up to 400 °C. Flux CEWELD® FL 838 or fused flux CEWELD® FL 880

CLASSIFICATION

AWS	A 5.9: ER318
EN ISO	14343-A: S 19 12 3 Nb
W.Nr.	1.4576
F-nr	6
FM	5

CONVIENT POUR

1.4301, 1.4306, 1.4401, 1.4404, 1.4408, 1.4420, 1.4435, 1.4436, 1.4541, 1.4550, 1.4571, 1.4573, 1.4580, 1.4581, 1.4583
X 6 CrNiMoTi 17 12 2, X10 CrNiMoTi 18 12, X 6 CrNiMoNb 17 12 2, G-X 5 CrNiMoNb 18 10, X 10 CrNiMoNb 18 12, X 5 CrNiMo 18 11, X 2 CrNiMo 17 13 2, G-X 2 CrNiMo 18 10, X 2 CrNiMo 18 14 3, X 5 CrNiMo 17 12 2, G-X 6 CrNiMo 18 10, X 5 CrNiMo 17 13 3
UNS S31600, S31603, S31635, S31640, S31653,
AISI 316, 316L, 316Ti, 316Cb

AGRÉMENTS

CE

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.035	0.5	1.6	0.02	0.02	19	12.5	2.75

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-110°C	
As Welded	390	590	30	110	47	HRc

ETUVAGE

Not required

GAS ACC. EN ISO 14175